

5/19

DART AEROSPACE LTD	Work Order:	23005
Description: Doubler	Part Number:	D3293-1
Dwg: D3293 Rev. A	Qty:	40 38
		Page 1 of 1

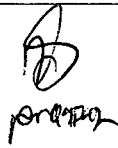
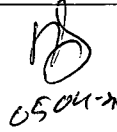
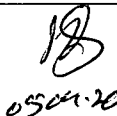
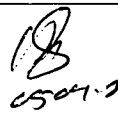
Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: To be made in multiples of 10	PH	05.04.13	40
2	MV	Cut blanks: 20.300" x 11.800" Material: 2024-T3 (QQ-A-250/4) 0.080" thick (M2024T3S.080) Identify for D3293-1 Batch: M15628 M14646	Er	05.04.18	40
3	MV	Machine as per Folio FA444 and Dwg D3293 Stack of 10 Identify as D3293-1	SD	05.04.19	38
4	QC2	Inspect parts as they come off the CNC machine	SD	05.04.19	38
5	QC8	Second check	Er	05.04.20	38
6	GA	Deburr	A	05.05.03	38
7	FP	Acid etch and alodine as per QSI 005 4.1	J	05.05.03	38
8	FP	Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3	FF	05/5/10	38
9	QC3	Inspect Powder Coat	M	05.05.10	38
10	ST	Identify and Stock	CH	05/05/12	38
11	AC	Cost / part 29.78	AF	05/05/13	38
12	DC	Close W/O 30.15 Inspect Level 21	PH	05.05.17	38

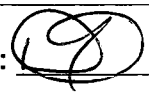
PROAP

Rev	Date	Change	Revised By	Approved
A	04.08.24	New issue	KJ/JLM	

RELEASED
04/08/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
0504-20	3	2 Scrap - End mill did not machine to bottom of stack - centre drill hole in wrong place		Destroy No replace	SN 0504-20	 0504-20	 0504-20	 0504-20

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 05/05/17

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. A	
DATE		TITLE	SHEET 1 OF 1	SCALE
04.06.28		DOUBLER		1:3
A	04.06.28	NEW ISSUE		

D3293-1 DOUBLER

MAKE PER DRAWING FILE "D3293-A1.DWG"

CHECK PER TEMPLATE D3293-1T1

DIMENSIONS SHOWN FOR REFERENCE ONLY

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK

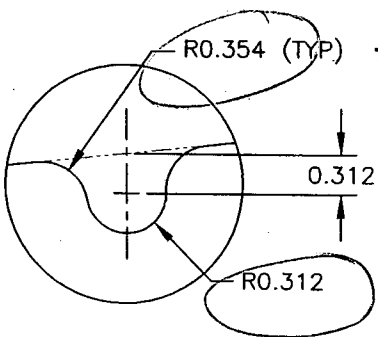
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER

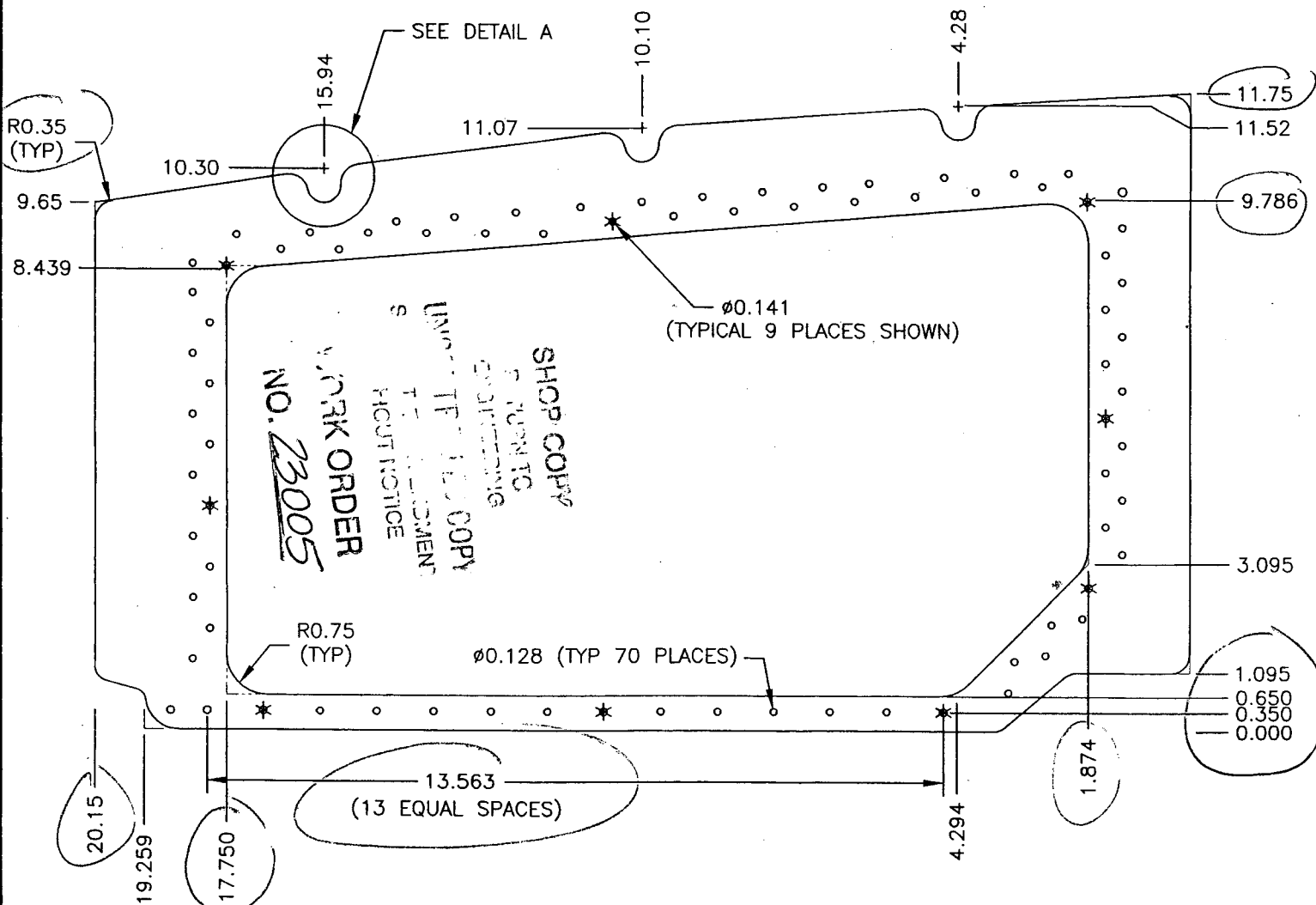
DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DETAIL A SCALE 2:3



RELEASED
04.07.12



Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 12, 2005
02:25 pm

Work Order No : 0023005
Project Name : D3293-1
Project For : WK519
Work Order Type : Main
Main WO Number :
House Part Number : D3293-1
Description : Doubler
Manufactured : Yes *C*
Amount Req'd : *10*
Amount Done : 0
Start Date : 04-12-05
Est Finish Date : 05-05-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
=====					
Burden :	0.00	0.00	0.00		
=====					
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00